

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSEMBLY
Job Number	: 41290-1	Part Number	: PB674300101
Estimate Number	: 13531	Drawing Number	: B6743001 P.1, 2
P.O. Number	:	Project Number	: N/A
This Issue	: 23/09/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: 18/08/2008 Type : SMALL /MED FAB	Due Date	: 15/09/2008
Previous Run	: 41237	Qty:	split 2 / 4 Um: Each
Written By	:		
Checked & Approved By	: MF 08-09-23		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwd Blade Fold Assembly Weldment batch: 4136 2 MF 08-10-24		
2.0	PB674300115	Fwf Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: 040608 x 2 MF 08-10-24		
3.0	PB674300111	Fwf Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: 40606 MF 08-10-24		
4.0	PB674300121	PB67-43001-21
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PB67-43001-21 batch: 41370 MF 08-10-24		
5.0	PB674300123	PB67-43001-23
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PB67-43001-23 batch: 41371 MF 08-10-24		



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Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Longitudinal Support Assembly

batch: 41013

MF 08-10-21

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Long T-Handle Assembly

batch: 41381

MF 08-10-21

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Lever Arm

batch: B 41294

MF 08-10-21

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bushing

batch: ~~B 40056~~ B.41373

MF 08-09-23

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

batch: B 40062

MF 08-09-23

11.0

D3451048

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B 41064~~ X 2

~~B 41076~~ B 42286

MF 08-10-24

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B 41063~~ X 2, ~~B 41279~~

MF 08-10-24

Not in comp.



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Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Square Spacer

batch: B 24416 x 6, B 41351 x 2

UMF 08-10-24

14.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Swing Arm

batch: B 41278 x 8

UMF 08-10-24

15.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Belt Assembly

batch: B 39966 x 4

UMF 08-10-24

16.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

batch: m17850 x 8

UMF 08-10-24

17.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

batch: B18431

UMF 08-10-24

18.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

SCREW

batch: 18057

UMF 08-10-24

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: 108701

UMF 08-10-24

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

batch: M107499

MF 08-10-24

21.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch: M105077

MF 08-10-24

22.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: M108473

MF 08-10-24

23.0

~~MS518596~~

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: M108986

106421

MF 08-10-24

24.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPACER

batch: M108473 X 8

MF 08-10-24

25.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

WASHER

batch: M108473

MF 08-10-24

26.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Washer

batch: 10818057

MF 08-10-24

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Machine Or Operation:

Description :

27.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: 108057

MF 05-10-24

28.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

WASHER

batch: 18057

MF 05-10-24

29.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch: 4085

MF 08-10-24

30.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: m103962 x4, m101291 x4

MF 08-10-24

31.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: m107959

MF 08-10-24

32.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

batch: 19278

MF 08-10-24

33.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: m105558

MF 08-10-24

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Job Number:



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Machine Or Operation:

Description :

34.0

~~AN620A~~

Bolt



AN6C16A *epc*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: ~~m109547~~ M105831

mf 08-10-24

35.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: m18180.

mf 08-10-24

36.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

RIVET

batch: m109119 x10, ~~m10911~~ m17890 x6

mf 08-10-24

37.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

cherry rivet

batch: m104214.

mf 08-10-24

38.0

~~MS17984C406~~

PIN, QUICK RELEASE



MS17984C-410 *epc*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: ~~m108986~~ M18118

mf 08-10-24

39.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: m108991 x4, m108986 x4.

mf 08-10-24

40.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

8" LANYARD

batch: m108390

mf 08-10-24

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Job Number:



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Machine Or Operation:

Description :

41.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

LANYARDS

batch: m108973

MF 08-10-24

42.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

SPRING SLOTTED PIN

batch: m17850

MF 08-10-24

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M109687

Cpl 08.10.24

SAD 08.10.24

MF

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/24 (x2)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PNP B41180 B41181

Cpl/24 (2)

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) 08/10/24

Job Completion



MF 08-10-24



NOTICE: INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE POLICY OF THE AIR FORCE TO RELEASE INFORMATION TO THE MAXIMUM EXTENT POSSIBLE.

REV STATUS SHEET 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45

NOTES: DIMENSIONS OTHERWISE SPECIFIED:

1. IDENTIFY PARTS PER PREMIER INSTRUCTION LOCATION AND MARKING PROCEDURES 115-12112 LOCATION CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED FOR MACHINED PARTS. REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
3. GENERAL SHOP PRACTICES I, A, W, PREMIER SPEC. 000-93000 AND ACAS, 13.
4. GWT.
5. WELD PARTS PER MIL-2218, CLASS B.
6. CHAIN FILM (ALUMINUM) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC 000-93003, CLASS 1A, AND PRIME WITH EPOXY PRIMER PER MIL-8-2317C, ZINC CHROMATE PRIMER PER MIL-17P-1251, OR EQUIVALENT.
7. STITCHING PER FED-510-751.
8. WITH THE INNER TUBE CRADLE ASSEMBLY LOCATED IN ITS MOST EXTENDED POSITION (HANDLE LOCKED ON OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND JAWARD FROM THE OUTER SIDE OF THE OUTER TUBE UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST MOST RESISTED POSITION. MATCH DRILL TO OUTER TUBE .25 DIA.
9. INSTALL: FITTOM TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT 000203 SET PIN. AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL 12 PL 1A BUSHING TO CONTOUR OF TUBE.
10. GRIND BUSHING AND WELD TO CONTOUR OF TUBE.
11. AFTER CRADLE ASSEMBLY BUSHING ON THE OTHER END OF THE TUBE WELD BUSHING ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.
12. CRADLE TOOK FOR BETTER WELDING.
13. TAP HOLE TO 1/4-20 THRU.
14. INSTALL CL-46-SEP-3 DETENT BALL INTO HOLDING FASTENING SO THAT THE BALL IS POSITIVELY LOCKED SLIGHTLY ABOVE FLUSH WITH THE TUBE. IN THE FUTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FITTING AND ADJUST FOR PROPER STOWING.
15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT WASHES FOR WASHES 1149 WASHES UNTIL CORRECT STOCK IS DEPLETED.
16. PAINT ALL ASSEMBLIES AND WEAPONS AS REQUIRED EXCEPT WHITE WOTER, 236633 W OSHA YELLOW, PER FED-510-525. NO PAINT REQUIRED, CHAIN FILM ONLY WHERE APPLICABLE. PER PREMIER SPEC 000-93003.
17. STITCH APPROX AS SHOWN, PER FED-510-751.
18. PERMISSIBLE TO TRIM WELDED WASHES OR SUBSTITUTE WITH TRIMMED WASHES EQUIVALENT.
19. DISASSEMBLE -53 HANDLE ASST (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF .01 OR .02 DIAMETER ASST TO AIRCRAFT.

REFERENCE ONLY

ECO
5007
5161
6262

RELEASED
06-01-20

REVISIONS

REV	DATE	DESCRIPTION
1	10/12/75	W.C. WILLIAMS
2	11/1/75	CHANGES TO IMPROVE FUNCTIONALITY
3	01/01/76	TO REFLECT BLT MODIFICATIONS
4	01/01/76	TO REFLECT BLT MODIFICATIONS

EXAMINED UNDER AIRCRAFT

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PREMIER AVIATION, INC.

BLADE FOLD KIT

DOSUVA B67-43001

SEE SEPARATE PARTS LIST B67-43001PL

ORIGINAL

REFERENCE ONLY